

## AQUAPEKS 1101

### MP-1101 (G)

#### Product Information:

AQUAPEKS 1101 is a 1C PUR Dispersion for 3D applications.

#### Application Areas

- PVC, ABS and PET foils in thermoforming presses (with and without membrane) and vacuum presses
- Particularly suited for edges and for door skin application

#### At a Glance

- Free of solvent
- Clean spraying
- High green tack
- High solid content

#### Technical Data

pH value (20 °C) ISO 976	7 to 10
Viscosity, Brookfield	
RVT, 3/20/20, mPa.s ISO 2555	1.200 to 2.000

(\*) Typical properties, not to be used as specification

#### Instructions for Use

In general, AQUAPEKS 1101 is a one-component glue system without additional cross-linker.

The working temperature of the workpiece and glue should be over +18°C to achieve optimal bonding results. Lower working temperature results in higher viscosity of the glue. The glue mix is sprayed with an appropriate spraying gun (nozzle size: 1.4 to 2 mm). As a rule, it is sufficient to apply one coat to the flat surface. Open pore inner and outer radii, however, need to be coated a second time after a brief drying interval. The pre-glued pieces should be sealed within 3 days to achieve optimum bond.

Drying time depending on temperature, humidity and quantity applied	≥30 minutes
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Activation temperature in the glue line at the edges	60°C
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Curing time complete curing after 7 days	24 hours
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All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic.

Please note: temperatures above +25°C will shorten the max. storage time of pre-coated fronts

#### Storage

The glue should be transported and stored in the tightly closed original container at temperatures above +10 °C and below max. +30 °C.

Cooling below +10 °C can lead to coagulation.  
Storage life up to 6 months.

#### Packaging

30 kg metal drums or PE pail

#### Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

#### Processing

Reactive hotmelt adhesives have a limited thermal stability even when working at the specified working temperatures; therefore, we recommend that after a period of 4 hours without production, that the unit is either switched off, or the set temperatures on the unit be reduced to 60°C. Since the product will cure when it is exposed to moisture, storage and application must be done under dry conditions. For this reason, the product is delivered in airtight containers.

#### Safety

The product contains diphenylmethanedisocyanate. Even if the product is applied within the range of the recommended working temperature, the disocyanate has a detectable vapour pressure. When the recommended working temperature is considerably exceeded, hazardous decomposition products may be formed in the application unit; therefore, measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment. In case of skin contact with the hotmelt, do not try to remove the adhesive from the skin by force. Consult a doctor. Observe the material safety sheets.

#### Disclaimer:

The statements listed on this publication are according to our best knowledge. The statements do not exonerate the user from their own responsibility to determine that our products are suitable for their processes. They are intended to inform and advise and are subject to influence from the technical process.  
This edition of December 22, 2023 replaces all previous editions. With the present edition all older editions are null and void.

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